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D412-630-033
Job Sheet 190422



Part No: D412-630-033

Job Qty: 1 ea **4**

Part Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/8/19

Job Tracking No:

Due Date: 3/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV O IPP Rev:A New Issue 06-11-08 JLM IPP rev B ecn 1019, added d2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC IPP REV:D 13.06.07 PER CHG004 DD vef:JLM IPP REV:E
16.06.23 AS PER IIN REV.O DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/12/19	3/12/19	0.00	0.00	Start Up Small Fab-4		DAS 36 9-89
110	Small Fab	1 pcs	3/12/19	3/12/19	0.00	0.44	Small Fab-6		DAS 36 9-89
120	QC	1 pcs	3/12/19	3/12/19	0.00	0.00	QC5		MAR 20 2019 DAS 40 9-89
130	Packaging	1 pcs	3/12/19	3/12/19	0.00	0.00	Packaging1-4		MAR 20 2019 DAS 40 9-89
140	QC	1 pcs	3/12/19	3/12/19	0.00	0.00	QC4		MAR 20 2019 DAS 40 9-89
150	Packaging	1 pcs	3/12/19	3/12/19	0.00	0.00	Packaging3-2		MAR 20 2019 DAS 40 9-89
155	DC	1 pcs	3/12/19	3/12/19	0.00	0.00	DC		MAR 21 2019 DAS 40 9-89
160	QC21-FG	1 Ea	3/12/19	3/12/19	0.00	0.00	QC21		MAR 21 2019 DAS 40 9-89

Part Op 110 - Assemble as per dwg D412-630 p.14 Coat all hardware with LPS3 rust inhibitor A/R LPS3 batch: No Batch
Descriptions: COAT exposed HARDWARE WITH LPS PROCYON . A/R LPS PROCYON BATCH: 1133690
150 - Identify and pack for shipping as per PPP D412-630-033
155 - Photocopy bluefile & create labels per PPP D412-630-033 CHG005

Bush!!!

Pick now Plz

008759

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310C8 ⁵⁷ 331	Nut	82 Ea (2 ea)	90-Start up Operation	5103998
AN3C21A ³⁴⁸	Bolt	41 Ea (1 ea)	90-Start up Operation	Fm137680-0
AN8C16 ³³²	Bolt	82 Ea (2 ea)	90-Start up Operation	5156472
D2012-107 ⁰⁰¹	Clevis	41 pcs (1 ea)	90-Start up Operation	5040916
D2803-041	Bracket Assembly	41 pcs (1 ea)	90-Start up Operation	5161475 x2 5044581
D2804-041 ⁴⁷⁴	Bracket Assembly	41 pcs (1 ea)	90-Start up Operation	5161467
D2807-041 ⁰¹¹	Prop Assembly	82 pcs (2 ea)	90-Start up Operation	2x5153522 6x5146685
D2813 ⁰¹¹	Washer	82 pcs (2 ea)	90-Start up Operation	5149998
D3395-1 ⁰³³	Bushing	164 pcs (4 ea)	90-Start up Operation	5041201
D3562-041 ^{PKg} 047	Step Weldment	41 pcs (1 ea)	90-Start up Operation	5146612 x2 5148927 x2
D3672-15 ⁰⁴⁷	Phenolic Washer	205 pcs (5 ea)	90-Start up Operation	5042894
D3672-19 ⁰⁴⁸	Phenolic Washer	164 pcs (4 ea)	90-Start up Operation	F148075
D3672-7 ⁰⁴⁷	Washer, Phenolic	164 pcs (4 ea)	90-Start up Operation	5131568
MS21043-3 ³⁰²	Nut	164 Ea (4 ea)	90-Start up Operation	5149144
MS24665-302 ²⁹⁹	Cotter Pin	82 Ea (2 ea)	90-Start up Operation	5156979
MS24693-C280 ²⁹⁷	Screw	82 Ea (2 ea)	90-Start up Operation	5137597
MS24693-C285 ²⁸⁷	Screw	41 Ea (1 ea)	90-Start up Operation	5142073
AN44C7A	Eyebolt	41 Ea (1 ea)	130-Packaging	5142070
AN4C10A	Bolt	41 Ea (1 ea)	130-Packaging	5143545
AN4C15A	Bolt	42 Ea (2 ea)	130-Packaging	5104456
AN4C6A	Bolt	41 Ea (1 ea)	130-Packaging	5100397
AN5C15A	Bolt	42 Ea (2 ea)	130-Packaging	5099540
D2806-1	Bushing	42 pcs (2 ea)	130-Packaging	5146106
D2806-3	Bushing	42 pcs (2 ea)	130-Packaging	5146101
D2810-5	Strut	41 pcs (1 ea)	130-Packaging	5147497
D3396-1	Spacer	82 pcs (2 ea)	130-Packaging	5144111
D3672-17	Phenolic Washer	287 pcs (7 ea)	130-Packaging	F150886
D3672-5	Washer, Phenolic	287 pcs (7 ea)	130-Packaging	F753354-25
MS21043-4	Nut	164 Ea (4 ea)	130-Packaging	5149143
MS21043-5	Nut	123 Ea (3 ea)	130-Packaging	5099519

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DART
AEROSPACE

Container No: S163785



Part: D412 - 630 - 033

Job No: 190422

Serial No/Batch: S163785

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH96 - 69 Issue JaelFAA:STC SR005951

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN310C8	2	21	0
	AN3C21A	1	19	0
	AN8C16	2	7	0
	D2012-107	1	12	0
	D2803-041	1	0	0
	D2804-041	1	2	0
	D2807-041	2	24	0
	D2813	2	30	0
	D3395-1	4	30	0
	D3562-041	1	4	0
	D3672-15	5	524	0
	D3672-19	4	156	0
	D3672-7	4	973	0
	MS21043-3	4	1,382	0
	MS24665-302	2	10	0
	MS24693-C280	2	64	0
	MS24693-C285	1	52	0
130-Packaging	AN44C7A	1	15	0
	AN4C10A	1	32	0
	AN4C15A	2	50	0
	AN4C6A	1	536	0
	AN5C15A	2	57	0
	D2806-1	2	17	0
	D2806-3	2	25	0
	D2810-5	1	17	0
	D3396-1	2	27	0
	D3672-17	7	59	0
	D3672-5	7	521	0
	MS21043-4	4	1,538	0
	MS21043-5	3	114	0
Part Specifications				
Specifications could not be found.				

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
7	7			D3672-5	WASHER (OR NAS1515H5)
		4	4	D3672-7	WASHER (OR NAS1515H5L)
		5	5	D3672-15	WASHER (OR NAS1515H3)
7	7			D3672-17	WASHER (OR NAS1515H4)
		4	4	D3672-19	WASHER (OR NAS1515H8)
		1	1	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C65)
		1	1	MS24693-C285	SCREW (OR MS24694-C76)